

304 R0.675X.091 W

Work Order ID 78310

January-05-12 8:31:58 AM

78310

Page 1

Item ID: D2282-7

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tube

Start Date: 05/01/2012 Start Qty: 250.00

250

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 250.00

250

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/01/05

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Dwg D2282 and Folio FA190
2-Deburr

SL 12-01-31

254

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 12-01-31

254

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ank 12/02/01

254

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78310***78310***

Page 2

January-05-12 8:31:58 AM

Item ID: D2282-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tube

Start Date: 05/01/2012 Start Qty: 250.00

250

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 250.00

250

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: W/A

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN LARGE FAB

EL 12-2-1 (1254)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/2/12 DJ

R 12-02-1
254

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-05-12 8:32:02 AM

Page 1

Work Order ID: 78310

78310

Parent Item: D2282-7

D2282-7

Parent Item Name: Tube

Start Date: 05/01/2012

Required Date: 23/03/2012

Start Qty: 250.00

Required Qty: 250.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.675W.091		Purchased	No			100	f	113.3290	0.0666	17.52632			

M304TR0 675W 091

304 RD Tube .675 x .091W

**

12-01-51

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT017	113.329	
116386	69.989	
116856	40	
117598	3.34	

18 - could not pull mat'l

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

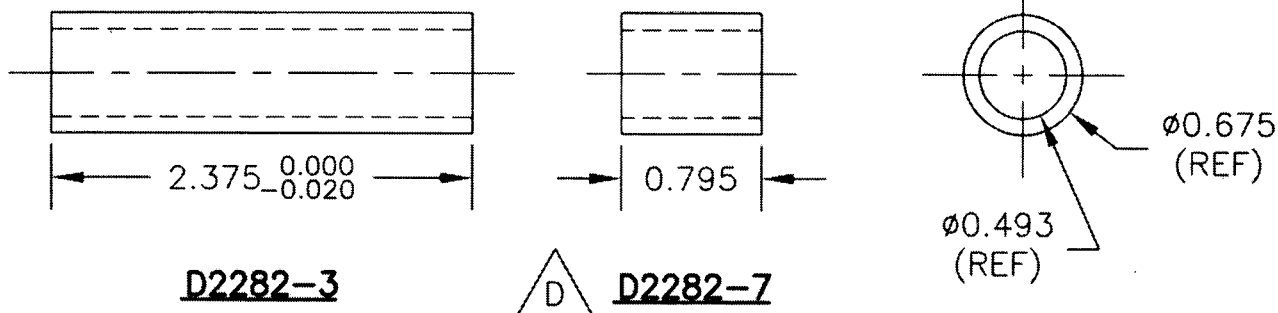
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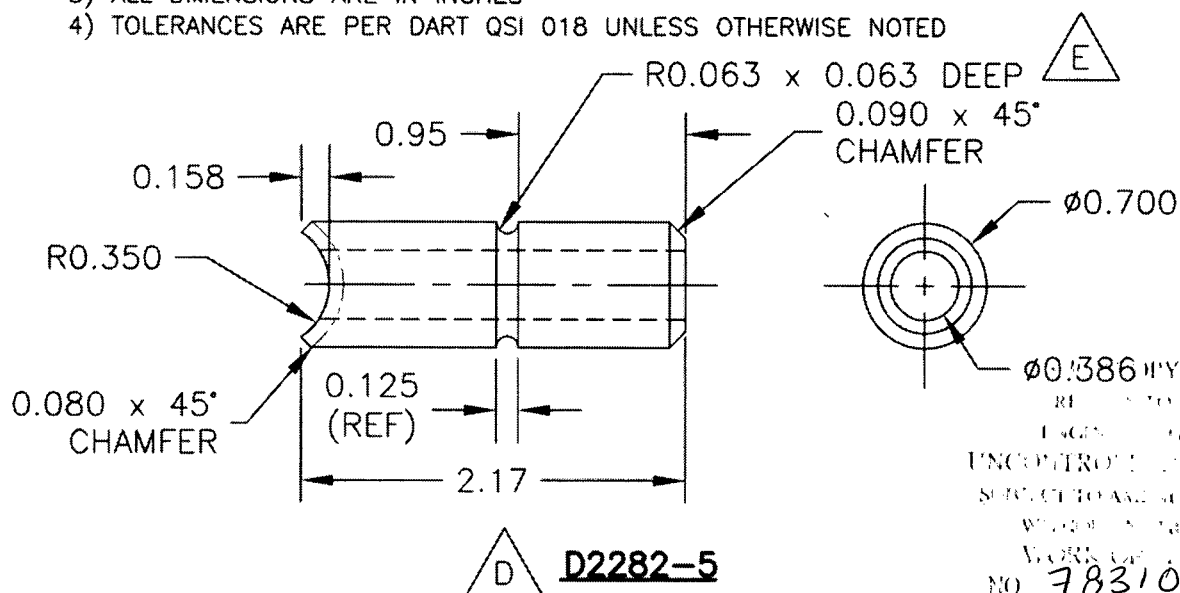
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]
05/09/16



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SERIAL TO AND FROM
WORK CENTER
NO. 7.8.310 M.C.J.

12/01/05

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

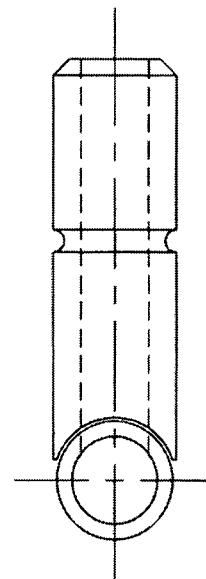
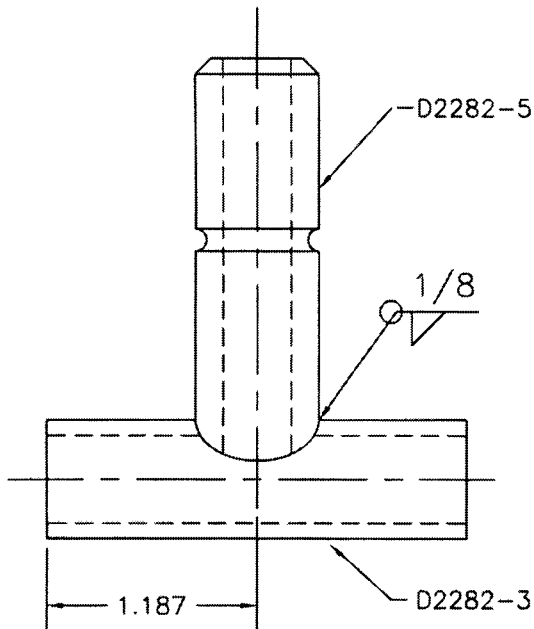
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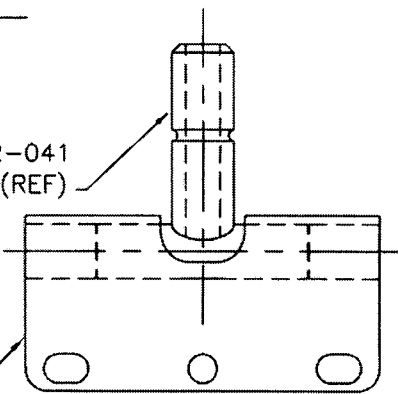


78310

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

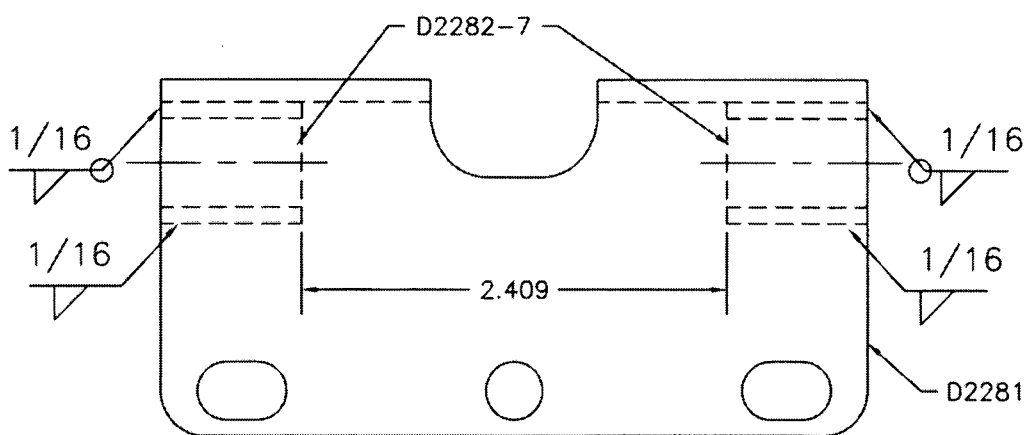


D2282-041
(REF)



D2282-043
(REF)

**GENERAL ASSEMBLY
SCALE 1:2**



**D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004**

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DART AEROSPACE LTD		Work Order:	78316
Description: Handle Tube		Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.795	+/-0.010	794	/		vern-13	
0.493	+/-0.010	503	/			
0.675	+/-0.010	672	/			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12-01-31	Date:	12/02/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	0.795 was 0.750	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	
D	07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

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